

Date: Thursday, 25/09/2008 8:49:09 AM  
 User: Linda Lacelle

## Process Sheet

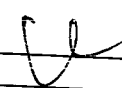
Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 42280  
 Estimate Number : 13099

Drawing Name : PANEL-350 FWD CANOPY

P.O. Number :  
 This Issue : 25/09/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 1/1 Type : THERMOFORMING  
 Previous Run : 42209

Part Number : D36563  
 Drawing Number : D3656 REV A B 08.09.25  
 Project Number : 00204  
 Drawing Revision : A B  
 Material :  
 Due Date : 02/10/2008

Qty: 1 Um: Each

Written By :   
 Checked & Approved By :  
 Comment : Est. Rev. A 07/12/13 DL verified by:DD

## Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description:

1.0 MLEXS093F600607

GE PLASTICS LEXAN SHEET



Comment: Qty.: 34.6600 sf(s)/Unit Total: 69.3200 sf(s)  
 GE PLASTICS LEXAN SHEET  
 batch: M107574

2.0 HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks to fit frame size

3.0 THERMOFORMING

THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3656-3 and Folio FTA 016 using tool DT8987

Dwg. Rev. B

Folio Rev. B

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3656-3 PAR #: NIA Fault Category: Prod / Performance NCR: Yes No DQA: A Date: 08/10/10  
D350-766-013  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: A Date: 08/10/10

NCR: <u>42280</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/09/08</u>	<u>4.</u>	<u>4 units scrap, webs and poor mould design.</u>	<u>[Signature]</u> <u>08/10/08</u>	<u>Scrap 4 units - mould to be replaced by PCM (with design change)</u>	<u>08/09/08 BB</u> <u>ph.</u> <u>08/10/08</u>		<u>[Signature]</u> <u>08/10/08</u>	<u>[Signature]</u> <u>08/10/08</u>
		<u>RC: Tooling.</u>						

NOTE: Date & initial all entries

Date: Thursday, 25/09/2008 8:49:09 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL-350 FWD CANOPY

Job Number: 42280

Job Number:

Part Number: D36563



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

08-10-09 ①



6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

BB 08/10/09 (X1) ①



1) Trim to Finished Dimensions as per dwg D3656

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE



Check dimensions to ensure conformity to drawing tolerances.

BB 08/10/09 (X1)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-10-09 ①



9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

IP 42207

08-10-09 ①



10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



08/10/10

Job Completion



MF 08-10-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	42280
<b>Description:</b> Panel		<b>Part Number:</b>	D3656-3
<b>Inspection Dwg:</b> D3656	<b>Rev:</b> A B 02 08.02.25	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition				
Free of visual flaws (bumps, cracks, voids, etc.)	✓		Vis	
	✓		Vis	

Measured by: BB

Date: 08/10/09

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.040	Min	.81	✓			
0.045	Min	.55	✓			
0.050	Min	.60	✓			

Measured by: BB

Audited by: A

Prototype Approval: N/A

Date: 08/10/09

Date: 08/10/09

Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DL	BB

8 7 6 5 4 3 2 1

D

C

B

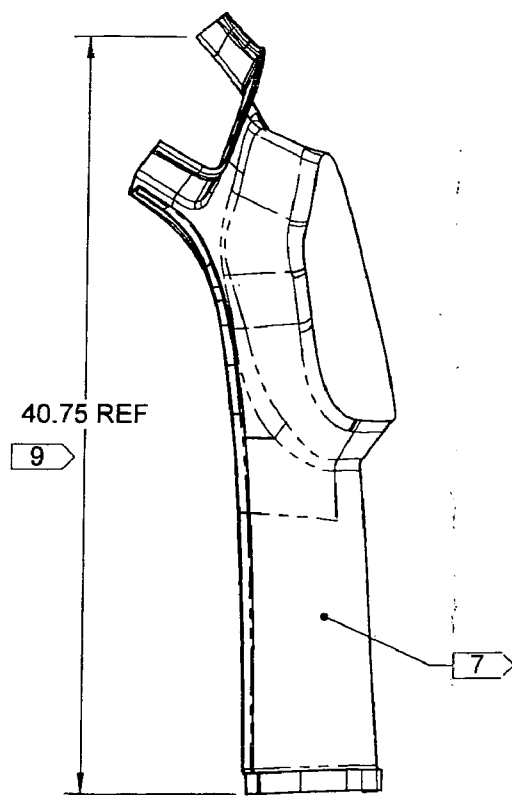
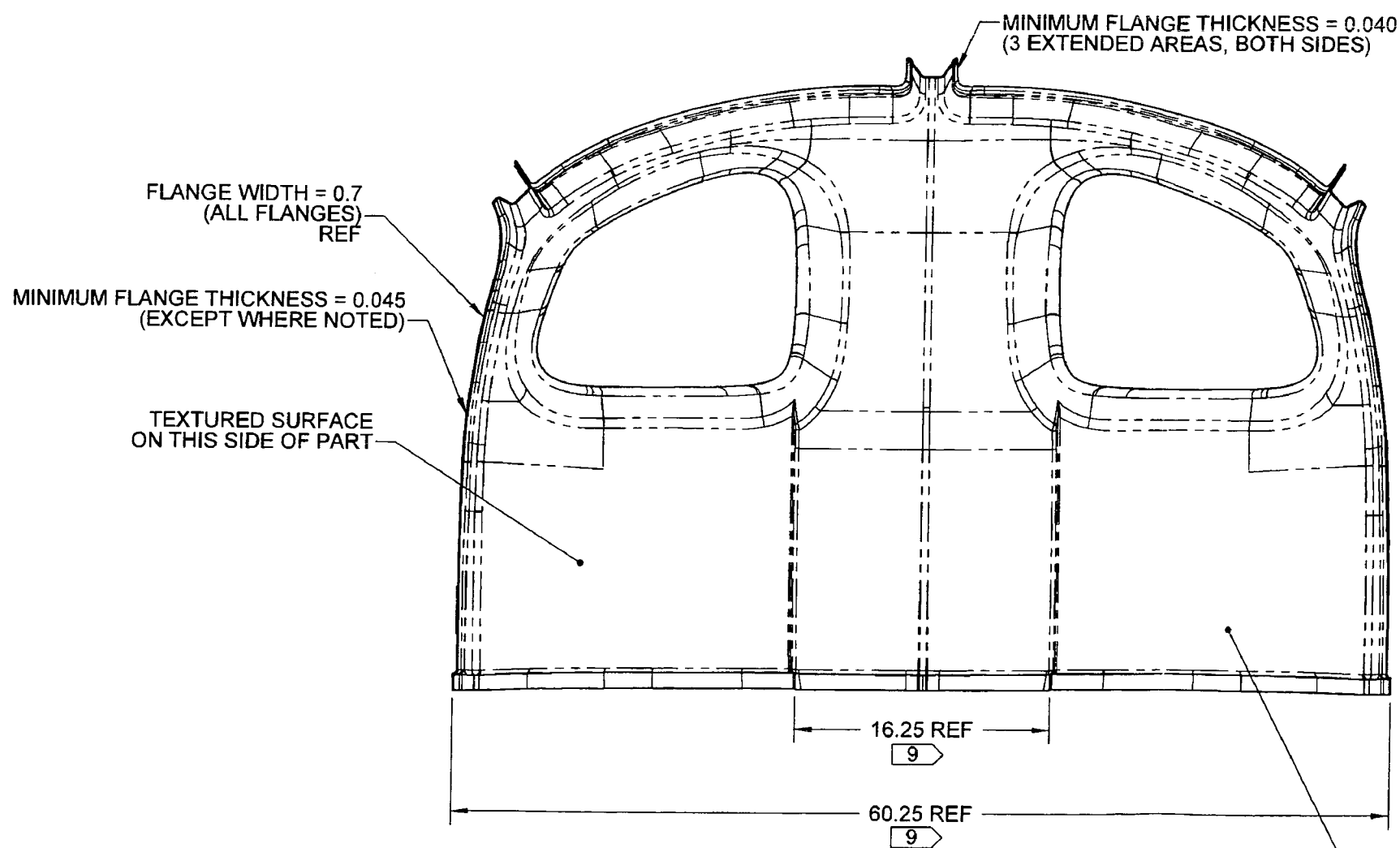
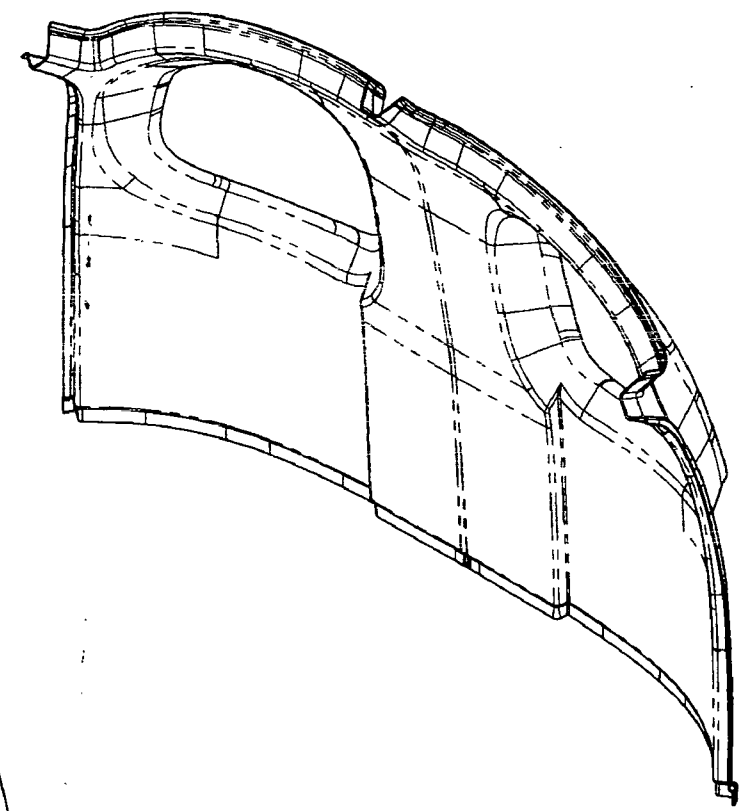
A

D

C

B

A



MINIMUM THICKNESS = 0.050  
(ALL OVER EXCEPT FLANGES)

**D3656-3 PANEL**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 42280

**RELEASED**  
08.09.30

**RELEASED**

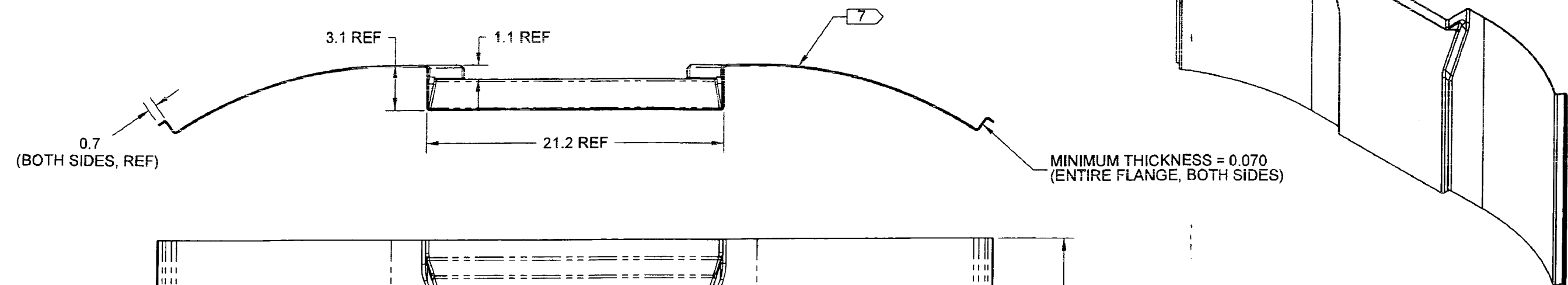
- NOTES:
- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK  
(REF DART SPEC MLEXS.093-F6006-07)
  - 2) TOOLING: THERMOFORM PER MOLD DT8987 PER QSI 022  
TRIM PER DT8987
  - 3) FINISH: NONE
  - 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
  - 8) WEIGHT: 8.7 lbs
  - 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

DESIGN	LE	<b>DART AEROSPACE LTD</b>	
DRAWN	PA	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. B
MFG. APPR.	LE	D3656	SHEET 2 OF 2
APPROVED	LE	TITLE	SCALE
DE APPR.	LE	PANEL	NTS
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8 7 6 5 4 3 2 1

D

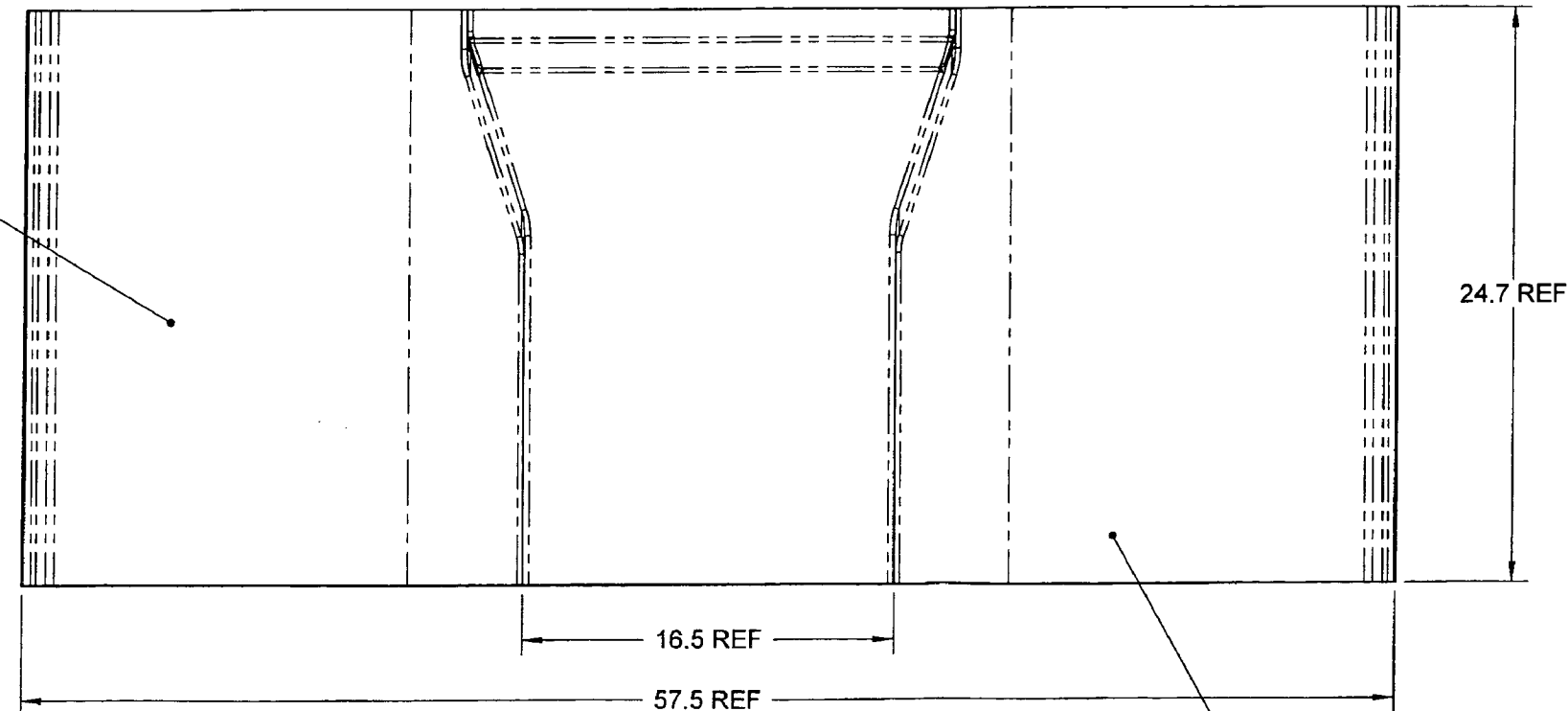
D



C

C

TEXTURED SURFACE ON THIS SIDE



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WITHOUT NOTICE  
WORK ORDER  
NO. 42280

RELEASED  
08-09-30 11:18

**D3656-1 PANEL**

**NOTES:**

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8986 PER QSI 022 TRIM PER DT8986
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 8) WEIGHT: 6.6 lbs
- 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

B	REMOVE SKYLIGHT CUTOUTS, UPDATED NOTE 2 (A6-2); REASON: EASE OF MANUFACTURE AND CUSTOMER REQUEST	PH	08.09.18
A	NEW ISSUE	LE	08.03.03
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	LE	D3656	SHEET 1 OF 2
APPROVED	LE	TITLE	SCALE
DE APPR.	LE	PANEL	NTS
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8 7 6 5 4 3 2 1

A

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